

Work Order ID 47709 - 2

July 6, 2009 9:56:53 AM



Page 1

Item ID: D3414-041

Accept



Setup Start



Revision ID: B

Item Name: Lug Assembly

Stop



Start Date: 07/06/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/09/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3414

Rev B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3414

Dwg Rev: _____

Prog Rev: _____

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Work Order ID 47709

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Page 2

Item ID: D3414-041
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Item Name: Lug Assembly

Accept

Setup Start
Stop

Start Date: 07/06/2009 Start Qty: 1.00
Required Date: 07/09/2009 Req'd Qty: 1.00

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date:
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start
Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120
QC
Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

130
Brake NC
Brake NC

Memo

1-Deburr
2-Form using DT8254 as per Dwg D3414

0.00

0.00

140
Large Fab
Large Fab

Memo

1- Weld using location Jig DT8484 as per Dwg D3414

0.00

0.00

Work Order ID 47709

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Page 3

Item ID: D3414-041

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Setup Start



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Item Name: Lug Assembly

Start Date: 07/06/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/09/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:15am
400F
10:45am

2111472 09-07-06

21

ff

Work Order ID 47709

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Page 4

Item ID: D3414-041

Revision ID: B

Item Name: Lug Assembly

Start Date: 07/06/2009 Start Qty: 1.00

Required Date: 07/09/2009 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: Date:

QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC3- Inspect Part Finish

0.00

pk 09-07-6

①



QC

Memo

0.00

Quality Control

190

Identify as per dwg & Stock Location: 473

0.00



Packaging

Memo

0.00

Packaging

9/7/09 SQ (14)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/09 JF

MF 09-07-08

Picklist Print

July 6, 2009 9:56:52 AM

Page 1

Work Order ID: 47709

Parent Item: D3414-041RevB

Parent Item Name: Lug Assembly


Comments: Rev:B rev.B as per dwg

Start Date: 07/06/2009

Required Date: 07/09/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ M304S12GA  304/316 0.100" Sheet		Purchased	No			100	sf	9.1100	1.5200			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

9.11

105130

9.11

✓ D3414-3RevB

Manufactured

No

160

Each

20.0000

1.0000

Lug

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

20

48382

20

Date: Monday, 04/05/2009 1:46:54 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : LUG ASSEMBLY

Job Number : 47709 - 2

Estimate Number : 10774

P.O. Number :

This Issue : 04/05/2009 S.O. No. :

Prsht Rev. : NC

First Issue : //

Type : LARGE FAB ASSY

Previous Run : 43451

Part Number : D3414041

Drawing Number : D3414 REV.B

Project Number : N/A

Drawing Revision : B

Material :

Due Date : 22/05/2009

Qty: 2 Um: Each

Written By :

Checked & Approved By : 2009.05.06

Comment : Est A 05.09.13 New issue KJ/JLM

Est Rev:B 09-02-26 rev.b as per dwg DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

M304S12GA

304/316 0.100" Sheet



Comment: Qty.: 0.1523 sf(s)/Unit Total: 1.8270 sf(s)

304/316 stainless steel 0.100" Sheet

Batch: 105130 B 9-5-07

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3414

Dwg Rev: B B 9-5-07

Prog Rev: B



2-Deburr if necessary B 9-5-07

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form using DT8254 as per Dwg D3414

counts
 509/05/08 (120)

SB 09/05/08 (E)

W/Q:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

y, 04/05/2009 1:46:54 PM

Lacelle

Process Sheet

er: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

umber: 47709

Part Number: D3414041

nber:



left in stock

seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



7.0

D34143

Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Lug

Pick:

Qty

Part Number Description

Batch

1

D3414-3

Lug

A/R

SS Rod

~~1102421~~

1 x 648382 9-7-2

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld using location Jig DT8484 as per Dwg D3414

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

9:00pm

OVEN TEMPERATURE:

400°F

FINISH TIME:

9:30pm

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

19

W/Q:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

er: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

umber: 47709

Part Number: D3414041

umber:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



[Signature]

[Signature]

Comment: PACKAGING RESOURCE #1

Identify with Dart P/N and B/N using a permanent fine point marker, then Stock

Location:

4B

[Signature]

SP

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

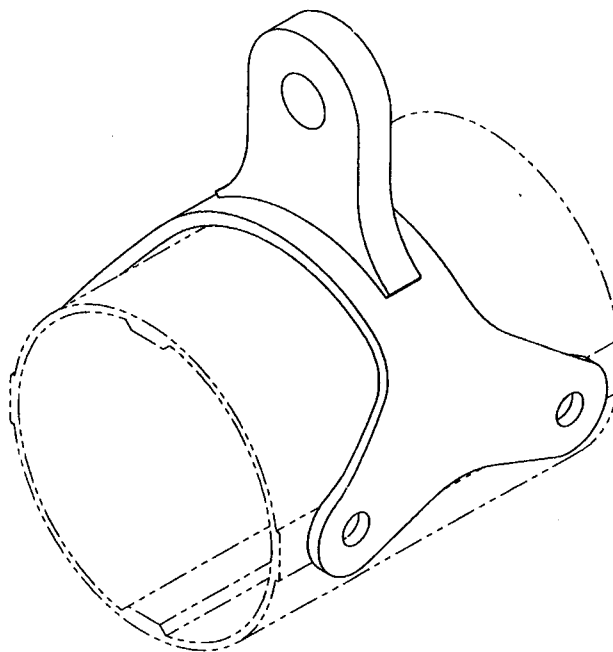
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
7	1	D3414-1	LUG BRACKET
8	1	D3414-3	LUG

△B



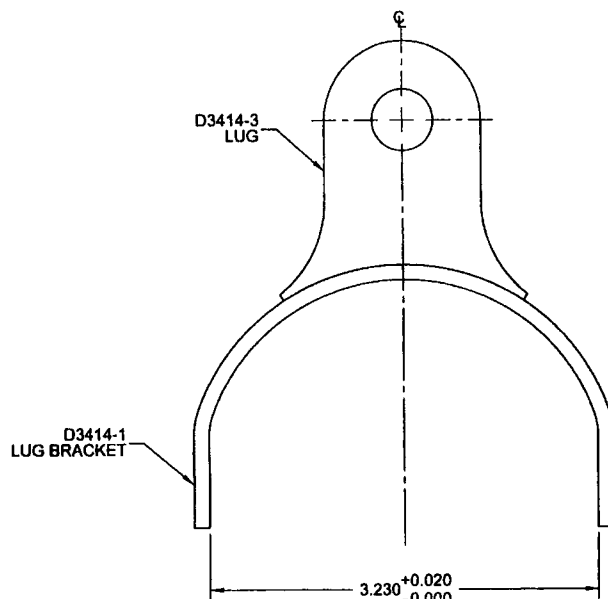
D3414-041 LUG ASSEMBLY

RELEASED
08/02/14

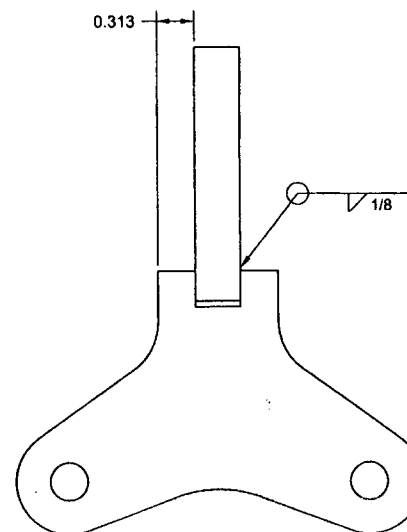
B		DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL. (SEE PAR198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. SHEET 3 ZONE B7 ADDED TOLERANCE TO 3.230 DIM.		AJS	08.09.23
A		NEW ISSUE		CP	05.03.18
REV.	DESCRIPTION			BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3414 TITLE LUG ASSEMBLY SCALE NTS			
DRAWN	AJS				
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.		REV. B		SHEET 1 OF 3	
DATE	08.09.23	COPYRIGHT © 2005 BY DART AEROSPACE LTD		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.52 lbs

NO. 47008
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY



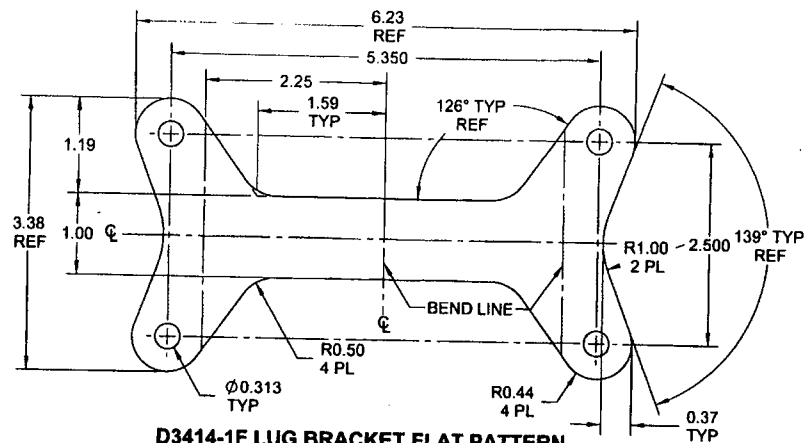
D3414-041 LUG ASSEMBLY



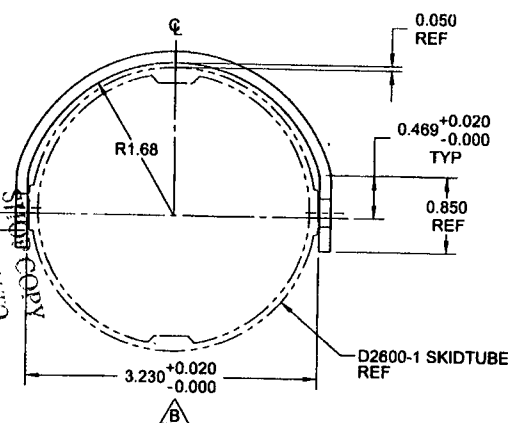
RELEASED
08/02/18

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 121708

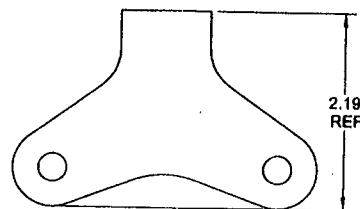
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3414	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
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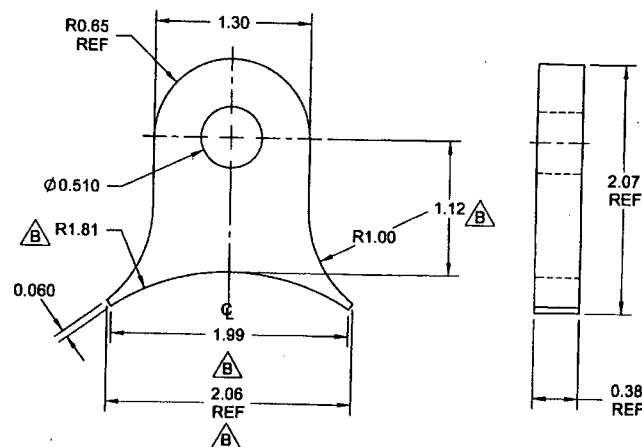
D3414-1F LUG BRACKET FLAT PATTERN



D3414-1 LUG BRACKET



SIDE VIEW FOR REF ONLY






D3414-3 LUG

- NOTES:**
- 1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5069 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA
 - 3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S

FINISH: N/A
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.010 TO 0.020 MAX
IDENTIFICATION: N/A
WEIGHT: N/A

RELEASED
08/02/13

DESIGN	QP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3414	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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